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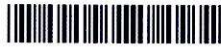
D2739
Job Sheet 213552



Part No: D2739

Job Qty: 4 pcs

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/29/20

Job Tracking No:

Due Date: 10/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs		10/29/20	0.00	4.64	Skidtubes - 1		DAS
							Skidtubes - 2		66 20/10/27
							Skidtubes - 3		9-89
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	4 pcs		10/29/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS
							QC 5 - 3		03 20.10.27
							QC 5 - 43		9-89
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
120	Handfinish - 1-1 Chemical-B4B	4 pcs		10/30/20	0.00	0.80	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		

Part: D2739
Job No: 213552
Serial No/Batch: S308697
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 10/27/20



Plex 9/29/20 2:51 PM Dart.lajeunesse.marie

DAS

03

9-89

20.10.29

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	4	10/30/20	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61

M/W 20.10.29

140 Packaging 3-1 - Stock - B4B	4 pcs	10/30/20	0.00 0.00	QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	Mkt 20-10-30
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	4 pcs	10/30/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS OCT 3 0 2020
				QC 21 - SA - 9	21
				QC 21 - SA - 77	9-09 OCT 3 0 2020
				QC 21 - SA - 28	

Part Op 100 - (Skid tubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

110 - QC5- Inspect part completeness to step on W/O

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7- Inspect Chemical Conversion Coat)

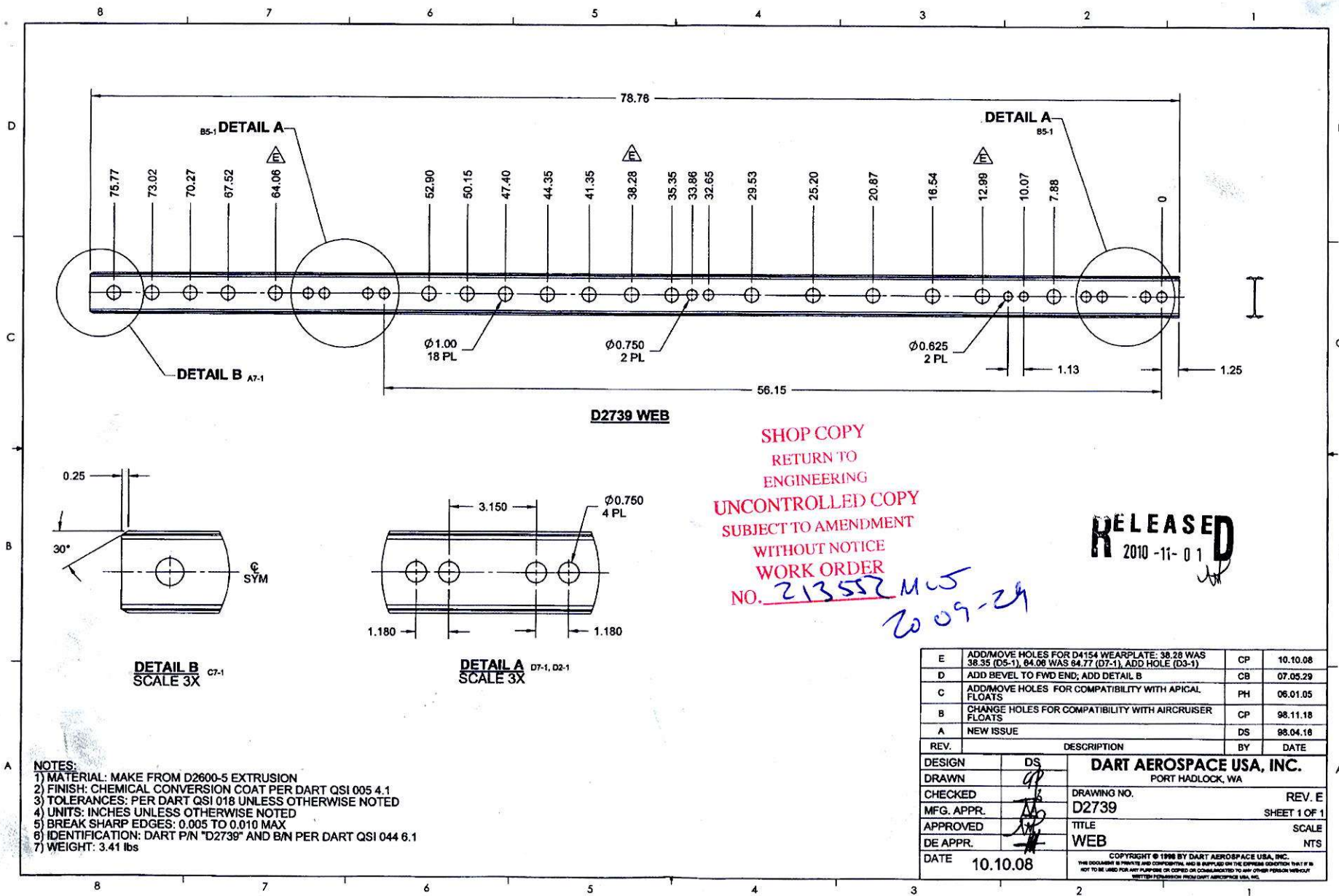
140 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	4 pcs (1 ea)	100-Skidtubes - 1	S146203

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2600-5-108	4	21	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Web	78.760Inches ± 0.030	78.790 78.730	
2	Web	1.180Inches ± 0.010	1.190 1.170	
3	Web	3.150Inches ± 0.010	3.160 3.140	
4	Web	1.180Inches ± 0.010	1.190 1.170	
5	Web	0.250Inches ± 0.030	0.280 0.220	
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle
7	Web	1.250Inches ± 0.030	1.280 1.220	
8	Web	7.880Inches ± 0.030	7.910 7.850	
9	Web	10.070Inches ± 0.030	10.100 10.040	
10	Web	12.990Inches ± 0.030	13.020 12.960	
11	Web	16.540Inches ± 0.030	16.570 16.510	
12	Web	20.870Inches ± 0.030	20.900 20.840	
13	Web	25.200Inches ± 0.030	25.230 25.170	
14	Web	29.530Inches ± 0.030	29.560 29.500	
15	Web	32.650Inches ± 0.030	32.680 32.620	
16	Web	33.860Inches ± 0.030	33.890 33.830	
17	Web	35.350Inches ± 0.030	35.380 35.320	
18	Web	38.280Inches ± 0.030	38.310 38.250	
19	Web	41.350Inches ± 0.030	41.380 41.320	
20	Web	44.350Inches ± 0.030	44.380 44.320	
21	Web	47.400Inches ± 0.030	47.430 47.370	
22	Web	50.150Inches ± 0.030	50.180 50.120	
23	Web	52.900Inches ± 0.030	52.930 52.870	
24	Web	64.060Inches ± 0.030	64.090 64.030	
25	Web	70.270Inches ± 0.030	70.300 70.240	
26	Web	73.020Inches ± 0.030	73.050 72.990	
27	Web	75.770Inches ± 0.030	75.800 75.740	
28	Web	56.150Inches ± 0.030	56.180 56.120	



Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					